

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 13.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013489**Date Inspected:** 27-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Oregon Iron Works Clackamas, Or.**Location:** Clackamas, OR

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|------------------------------------|----------------------------------|-----------|------------|----------------------------------|------------|----------------------|
| CWI Name: | M. Gregson, J. Salazar, G. Mundt | | | CWI Present: | Yes | No |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No N/A |
| | | | | Delayed / Cancelled: | Yes | No N/A |

Bridge No: 34-0006**Component:** Hinge K Pipe Beams**Summary of Items Observed:**

The Quality Assurance Inspector Sean Vance arrived on site at Oregon Iron Works, Inc (OIW) in Clackamas, OR, to randomly observe the in process welding of the Hinge K Pipe Beam assemblies. The QA Inspector arrived on site to randomly observe the OIW Quality Control (QC) Inspectors in process and completed visual and nondestructive testing. Upon the arrival of the QA Inspector the following observations were made:

Hinge-K Pipe Beam Assembly 102A-4:

The QA Inspector observed WID # (Craig Jacobson) and WID #B62 (Marcus Belagarde) attaching 2 pre-fabricated clamps to the a109 Cap and a110 Base plate. The QA Inspector observed that OIW Production Lead Troy Smith was present on this shift. Lead Troy Smith explained that the clamps were being placed and will be tightened, in preparation to move the assembly to the welding positioner. Lead Troy Smith explained that once the clamps are tightened, slings will be attached to the clamps and then the overhead Bay Crane will be utilized, to pick up the assembly and place in the positioner.

The QA Inspector later observed that these clamps had been tightened and that Lead Troy Smith and WID #B62 (Marcus Belgarde) were attaching 2 slings to the clamps. Lead Troy Smith explained to the QA Inspector that the slings were being attached, in preparation for lifting the Fuse and placement on the welding positioner. Once the slings were attached to the clamps, the QA Inspector observed WID #B62, utilizing the hand held control box for the overhead shop bay crane, to lower the lifting cable and attached hook. The QA Inspector then observed Lead Troy Smith attaching the previously placed slings to the hook. The QA Inspector then witnessed WID #B62 utilizing the hand held control box, to operate the shop crane and gradually lift the assembly from the shop floor. While the Fuse was being lifted, the QA Inspector observed Lead Troy Smith handling the Fuse to control the movement, during the lifting. Once the Fuse was lifted, the QA Inspector then witnessed WID #B62, utilize the

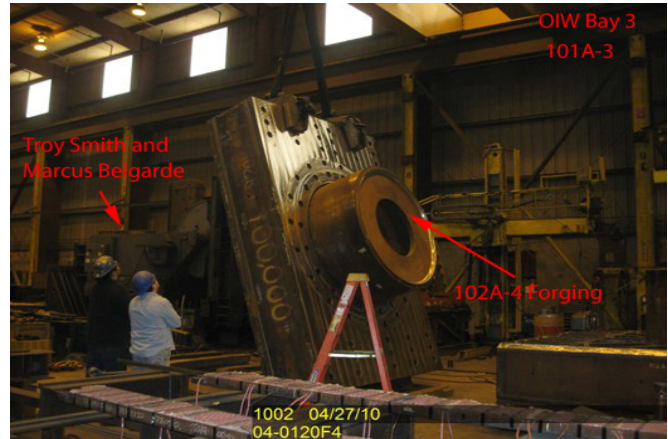
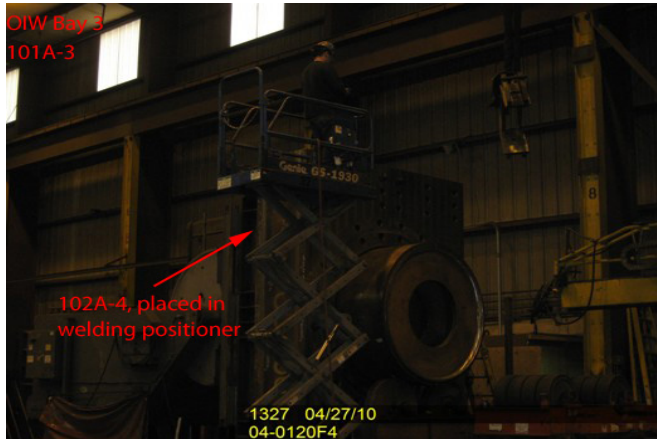
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hand held control to move the assembly in the East direction and gradually guide to the welding positioner. Once the assembly was placed next to the positioner, the QA Inspector observed Lead Troy Smith and WID #B62 insert threaded rods and tighten the attached clamps to secure. The QA Inspector noted that OIW will eventually place and fit the 120A-4 Fuse to this 102A-4 Forging. See attached pictures below.

Material, Equipment, and Labor Tracking (MELT)

QA Inspector Sean Vance performed a verification of material, personnel and equipment involved with the project. The QA Inspector observed at Oregon Iron Works: 4 OIW production personnel and 2 QC Inspectors.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

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| Inspected By: | Vance, Sean | Quality Assurance Inspector |
| Reviewed By: | Adame, Joe | QA Reviewer |
